

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022721**Date Inspected:** 28-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wong Xiang Pin, CWI Wang Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W

PCMK: SEG3020AV

Weld No: 011

Welder: 067609

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W

PCMK: SEG3020AV

Weld No: 006

Welder: 067829

WPS-B-P-2214-TC-U4b-FCM-1

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Components; OBG 13 W
PCMK: SEG3014F
Weld No: 216
Welder: 066674
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 14 W
PCMK: SEG3020AG
Weld No: 004~007
Welder: 066398
Weld Repair No. B-WR20428
WPS-345-SMAW-FCM Repair-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wong Xiang Pin, CWI Wang Jun.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG Traveler Rail
PCMK: TR3015TR-001
Weld No: 001,002
Welder: 047866, 067876
WPS-B-T-2232-ESAB

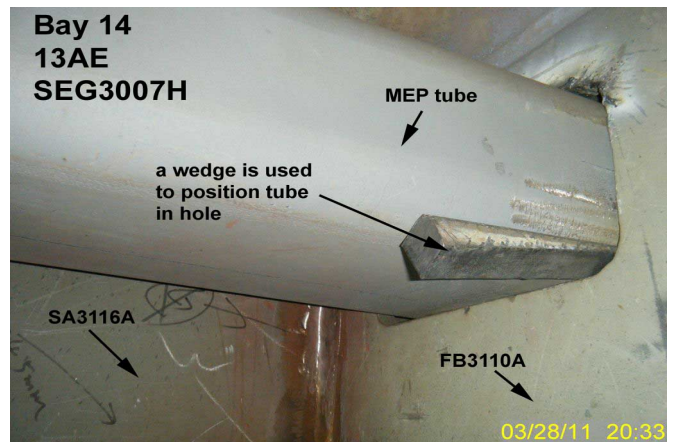
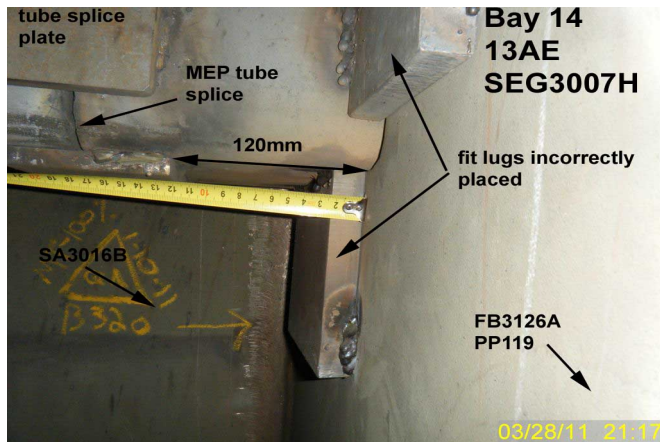
Components; OBG Traveler Rail
PCMK: TR3001TR1-001
Weld No: 001,014,015,
Welder: 067876
WPS-B-T-2231-ESAB

This QA Inspector performed document review for information requested by James Devy, and the Office of Structural Materials. This information request addresses OBG 14 west and 14 east, SEG3007H, Fit Lugs for MEP rectangular tubings. This QA Inspector performed random visual inspections of the rectangle tube location, fit size in floor beam hole, and rectangle tube splice interference with fit lug. It appears to this QA Inspector ZPMC is in process on 14 east and 14 west is on hold at this time. This QA Inspector took random photographs of the welds and copies of the photographs have been placed in "TC-RFI Documentation" folder located on Team China common Z drive.
(see photos below)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

“No relevant conversations.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer